

Date: Wednesday, 21/05/2008 10:29:06 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BUSHING
Job Number	: 39369		
Estimate Number	: 10175		
P.O. Number	:	Part Number	: D2570
This Issue	: 21/05/2008 S.O. No. :	Drawing Number	: D2570 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : MACHINED PARTS	Drawing Revision	: B
Previous Run	: 38724	Material	:
Written By	: <i>J. Menard</i> 08.05.21	Due Date	: 28/05/2008 Qty: 500 Um: Each
Checked & Approved By	:		
Comment	: Est E 02.08.29 Re-format; Removed finishing; Material changeK J est F 07.07.06 rev B dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M303R0750	303 Round Bar .75"
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504



Comment: Qty.: 0.0810 f(s)/Unit Total: 40.4775 f(s)
 Material: Ø0.750 AISI 303 SS Rod (M303R0.750)
 Batch M102857

mmf 08/05/21

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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504



Comment: HARDINGE CNC LATHE SMALL
 Machine as per folio FA198
 Deburr

J.F. / mmf 08/05/21

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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504



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / mmf 08/05/21

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J. Menard 08.05.28

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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504

Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: 37

8/5/29

504

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 39369

Part Number: D2570

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/29

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-29

DART AEROSPACE LTD		Work Order: 39369
Description: Bushing		Part Number: D2570
Inspection Dwg: D2570	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.800	+/-0.010	.802	✓			
0.060	+/-0.005	.063	✓			
R0.010	+0.010/-0.000	R0.010	✓			
Ø0.425	+0.000/-0.002	Ø.4249	✓			
Ø0.257	+0.005/-0.000	Ø.259	✓			
Ø0.750	+/-0.010	Ø.745	✓			
0.030 x 20°	+/-0.010	0.030 x 20°	✓			

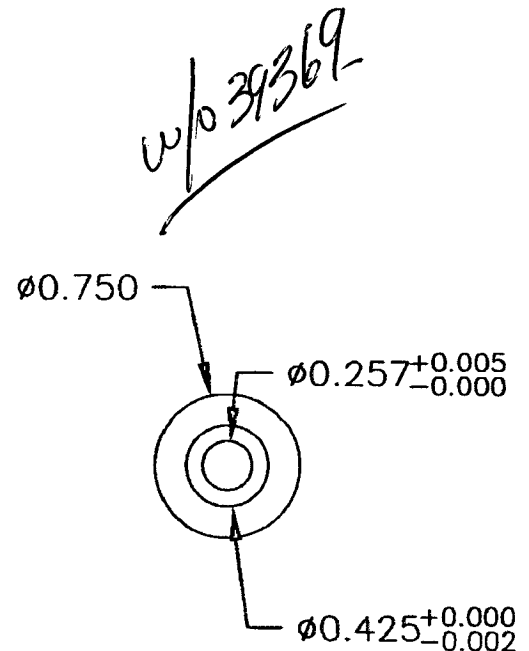
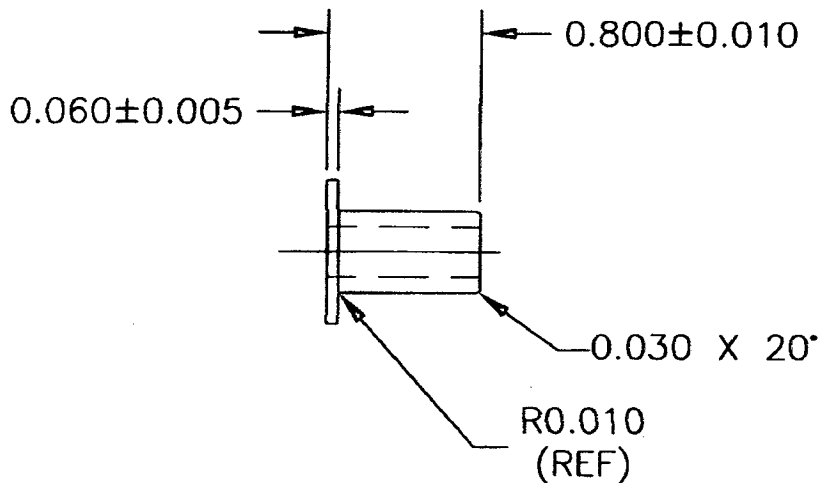
Measured by: mmf/lmf	Audited by: DJP	Prototype Approval: N/A
Date: 08/05/21	Date: 08/05/21	Date:

Rev	Date	Change	Revised by	Approved
A	03.12.08	New Issue	KJ/RF	
B	04.02.23	Tolerance for Ø0.425 changed	KJ/RF	
C	07.07.17	Dimensions updated per Dwg Rev. B	KJ/JLM	JA B



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2570	REV. B SHEET 1 OF 1
DATE 07.04.17		TITLE BUSHING	SCALE 1:1
A	96.09.16	NEW ISSUE	
B	07.04.17	UPDATE NOTES	

RELEASED
01.06.28 *[Signature]*



D2570 BUSHING

D2570 BUSHING

- 1) MATERIAL: AISI 303 ROUND BAR (REF. DART SPEC. M303R)
- 2) FINISH: NONE
- 3) ALL DIMENSIONS ARE INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL UNMARKED SHARP EDGES TO 0.010 MAX

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